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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23949
<b>Description:</b> Tube Guide	<b>Part Number:</b>	D3440-1
<b>Dwg:</b> D3440 Rev. A page 1	<b>Qty:</b>	20
Replaces Premier P/N: B67-43001-25/-307		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	AB	05/08/12	20
2	MV	Cut blank: 4.00" x 2.00" x 4.200" long Material: 6061-T6 or 6061-651/T6510/T6511/T62 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B2.000x04.000) <b>Identify for D3440-1</b> Batch: M18147	BG	05.08.22	20
3	MV	Machine as per Folio FA551 and Dwg D3440 Dwg Rev: A <b>Identify as D3440-1</b> Folio Rev: AA	gml	05/08/20	20
4	QC2	Inspect parts as they come off the CNC machine	gml	05/08/30	20
5	QC8	Second check	Er	05/08/30	20
6	MV	Deburr	gml	05/08/30	20
7	FP	Chemical Conversion Coat as per QSI 005 4.1	mm	05 08 31	20
8	FP	Powder Coat Green Sandtex (Ref: 4.3.5.8) per QSI 005 4.3 <b>Mask round section</b>	mm	05 09 12	20
9	QC3	Inspect Powder Coat	DL	05/09/13	20
10	ST	Identify and Stock	DL	05/09/13	20
11	AC	Cost / part: 38.43	SAC	05.09.14	20
12	DC	Close W/O 38.43 Inspect Level 21	RP	05/09/14	20

PTO


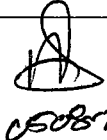


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Rev	Date	Change	Revised By	Approved
A	05.08.10	New issue	KJ/JLM	

RELEASED  
05.08.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.08.27	3	1 Spigot position out. Machine origin set wrong.		Destroy + Replace	BG 05.08.28	 CSOBTH	 R4PDA	 MSOBTH

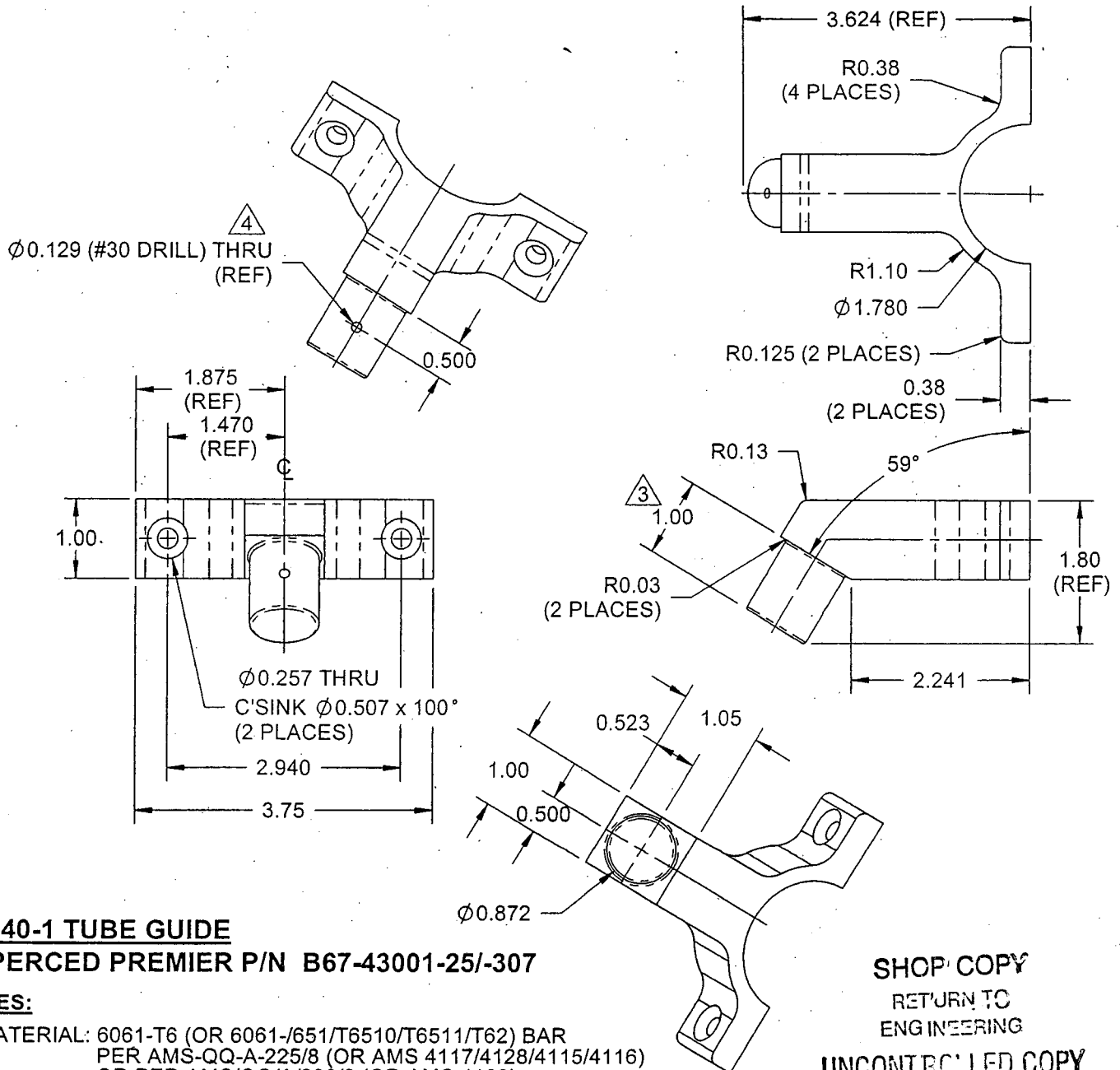
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 05/09/04

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3440	REV. A SHEET 1 OF 5
DATE	05.06.02	TITLE BLADE FOLD KIT PARTS	SCALE 1:2
A	05.06.02	NEW ISSUE	



## D3440-1 TUBE GUIDE

SUPERCED PREMIER P/N B67-43001-25/-307

### NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QT/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT MILITARY GREEN (4.3.5.XX) PER DART QSI 005 4.3
- 3) MASK BEFORE PAINTING.
- 4) DRILL HOLE AT ASSEMBLY.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE

WORK ORDER

NO. 23949

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 08, 2005  
01:28 pm

Work Order No	: 0023949	Department Code:	
Project Name	: D3440-1	Burden Flags	: NNNNNNNN
Project For	: WK535	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3440-1	Invoice Number	:
Description	: Tube Guide	Invoice Amount	: 0.00
Manufactured	: No		
Amount Req'd	: 020	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-04-05		
Est Finish Date	:	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

DART AEROSPACE LTD		Work Order: 23449 23949
Description: Tube Guide		Part Number: 03440-1
Inspection Dwg: 03440	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	±.010	.503				
1.875	"	1.877				
1.470	"	1.474				
2.940	"	2.937				
3.750	±.03	3.754				
1.00	"	1.003				
Φ.257	+0.006 -0.001	.258				
.507	±.010	.508				
3.624	±.010	3.620				
Φ1.780	+0.012 -0.001	1.781				
R.384	±.03	375				
R1.10	±.03	R1.1				
R.125	±.010	.125				
.38	±.03	.375				
R.13	"	.125				
59°	1/2°	59°				
1.80	±.03	1.807				
2.241	±.010	2.245				
1.00	±.03	1.000				
.523	±.010	.526				
1.05	±.03	1.050				
.500	±.010	.500				
1.00	"	1.000				
Φ.872	+0.010 -0.001	.875				

Measured by: BG	Audited by: EC	Prototype Approval: N/A
Date: 05.08.27	Date: 05.08.27	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

